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D3492-3

Job Sheet 207842



Part No: D3492-3

Job Qty: 80 pcs *100 pcs mfk*

Part Name: Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/5/20

Job Tracking No:

Due Date: 3/31/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	80 pcs		3/31/20	0.00	3.00	Hardinge - 1		DAS 66 20/04/04
120	QC 8	80 pcs		3/31/20	0.00	0.00	QC 8 - 12		9-89
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		h.e 20-04-06
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Handfinish - 1-1 Chemical-B4B	80 pcs		3/31/20	0.00	0.27	Handfinish - 1 - 1 - B4B		BER 20-04-07
							Handfinish - 1 - 2 -		

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				B4B			
				Handfinish - 1 - 3 - B4B			
				Handfinish - 1 - 4 - B4B			
				Handfinish - 1 - 5 - B4B			
				Handfinish - 1 - 6 - B4B			
				Handfinish - 1 - 7 - B4B			
				Handfinish - 1 - 8 - B4B			
				Handfinish - 1 - 9 - B4B			
				Handfinish - 1 - 10 - B4B			
				Handfinish - 1 - 11 - B4B			
				Handfinish - 1 - 12 - B4B			
				Handfinish - 1 - 13 - B4B			
				Handfinish - 1 - 14 - B4B			
				Handfinish - 1 - 15 - B4B			
				Handfinish - 1 - 16 - B4B			
				Handfinish - 1 - 17 - B4B			
				Handfinish - 1 - 18 - B4B			
				Handfinish - 1 - 19 - B4B			
				Handfinish - 1 - 20 - B4B			
				Handfinish - 1 - 21 - B4B			
				Handfinish - 1 - 22 - B4B			
140 Powdercoat - 1 White GI(A)- B4B 80 pcs 3/31/20				0.00	0.16	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
150 QC 3 80 pcs 3/31/20				0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
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M254469.

140 Powdercoat - 1 White GI(A)- B4B

80 pcs

3/31/20

0.00 0.16

Powdercoat - 1 - B4B

Powdercoat - 2 - B4B

Powdercoat - 3 - B4B

Powdercoat - 4 - B4B

START: 9:15 OUT: 3:00 FINISH: 9:45

150 QC 3

80 pcs

3/31/20

0.00 0.00

QC 3 - 10

QC 3 - 13

QC 3 - 15

QC 3 - 17

QC 3 - 18

QC 3 - 2

QC 3 - 28

QC 3 - 3

QC 3 - 30

QC 3 - 34

QC 3 - 36

QC 3 - 41

QC 3 - 51

QC 3 - 58

QC 3 - 59

QC 3 - 68

QC 3 - 9

QC 3 - 40

20-04-20

3-8-2020-04-20

34 9-89

DAS 59 9-89

				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
160 Packaging 3-1 - Stock - B4B	80 pcs	3/31/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	DEB 2020.0422
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	80 pcs	3/31/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-88
Part Op 100 - (Hardinge) 1-Turn as per Folio FA632 & Dwg D3492					APR 20 2020
Descriptions: 120 - (QC8- Inspect parts - second check)					
130 - (Chemical Conversion Coat per QSI005 4.1)					
140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) (Flat End Only)					
150 - (QC3- Inspect Part Finish)					
160 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001					
170 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6R0.750	6061-T6 Round Bar .750"	4.7200 ft (.059 ea)	100-Hardinge - 1	S265816	

Job Allocations				
Operation 100-Hardinge - 1	Component Part M6061T6R0.750	Required 5	Inventory 11	Allocated 0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type Special Comments
1	Plug	0.750inches $\pm$ 0.010	0.760 0.740	.745 Mic
2	Plug	0.582inches + 0.000 - 0.002	0.582 0.580	.582 LG-insp6 Mic
3	Plug	0.045inches + 0.000 - 0.002	0.045 0.043	.0445 LG-insp6
4	Plug	0.060inches $\pm$ 0.005	0.065 0.055	.058 cnc-21
5	Plug	0.060inches $\pm$ 0.005	0.065 0.055	.058 cnc-21
6	Plug	0.500inches $\pm$ 0.010	0.510 0.490	.498 Mic
7	Plug	0.090inches + 0.000 - 0.002	0.090 0.088	.089 cnc-21

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					